

# Work Order ID 146501

\*146501\*

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Wednesday, May 18, 2016 8:54:36 AM

Item ID: D2528-1 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Backer Plate

Start Date: 5/18/2016 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 5/31/2016 Req'd Qty: 20.00 \*20\* Customer:

Reference: DAS  
 13

Approvals: Process Plan: 9-89 Date: MAY 18 2016 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2528    | Rev C1       |

|                   |                                                                           |      |  |  |  |  |  |  |  |
|-------------------|---------------------------------------------------------------------------|------|--|--|--|--|--|--|--|
| 100               | FLOW WATER JET                                                            | 0.00 |  |  |  |  |  |  |  |
| *100*             |                                                                           |      |  |  |  |  |  |  |  |
| Waterjet          | Memo                                                                      | 0.80 |  |  |  |  |  |  |  |
| FLOW CNC Waterjet | 1-Cut as per Dwg D2528 Dwg Rev: C1 Prog Rev: C1 2-<br>Deburr if necessary |      |  |  |  |  |  |  |  |

|                 |                                         |      |  |  |  |  |  |  |  |
|-----------------|-----------------------------------------|------|--|--|--|--|--|--|--|
| 110             | QC2- Inspect parts off machine FAI/FAIB | 0.00 |  |  |  |  |  |  |  |
| *110*           |                                         |      |  |  |  |  |  |  |  |
| QC              | Memo                                    | 0.20 |  |  |  |  |  |  |  |
| Quality Control |                                         |      |  |  |  |  |  |  |  |

|                 |                                   |      |  |  |  |  |  |  |  |
|-----------------|-----------------------------------|------|--|--|--|--|--|--|--|
| 120             | QC8- Inspect parts - second check | 0.00 |  |  |  |  |  |  |  |
| *120*           |                                   |      |  |  |  |  |  |  |  |
| QC              | Memo                              | 0.40 |  |  |  |  |  |  |  |
| Quality Control |                                   |      |  |  |  |  |  |  |  |

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Item ID: D2528-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Backer Plate

Start Date: 5/18/2016 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 5/31/2016 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                                   | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp                   |
|--------------------------------|------------------------------------------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------------------|
| 130                            | Chemical Conversion Coat per QSI005 4.1                    | 0.00                 |         |        |              |               |               |                  |                                  |
| <b>*130*</b>                   |                                                            |                      |         |        |              |               |               |                  |                                  |
| HandFinish                     | Memo                                                       | 0.20                 |         |        |              | 26            | 28            |                  | 16/06/29                         |
| Hand Finishing                 |                                                            |                      |         |        |              |               |               |                  |                                  |
| 140                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum               | 0.00                 |         |        |              |               |               |                  |                                  |
| <b>*140*</b>                   |                                                            |                      |         |        |              |               |               |                  |                                  |
| Powdercoat                     | Memo                                                       | 0.20                 |         |        |              |               |               |                  |                                  |
| Powder Coating                 | START TIME: 10:20 OVEN TEMPERATURE: 350 FINISH TIME: 10:50 |                      |         |        |              |               |               |                  | 26 16-06-30 233                  |
| 150                            | QC3- Inspect Part Finish                                   | 0.00                 |         |        |              |               |               |                  |                                  |
| <b>*150*</b>                   |                                                            |                      |         |        |              |               |               |                  |                                  |
| QC                             | Memo                                                       | 0.20                 |         |        |              |               |               |                  |                                  |
| Quality Control                |                                                            |                      |         |        |              |               |               |                  | DAS<br>38<br>8-80<br>JUL 04 2016 |

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Item ID: D2528-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Backer Plate  
Start Date: 5/18/2016 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 5/31/2016 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty    | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|----------------------------------------------------|----------------------|---------|--------|--------------|---------------|------------------|------------------|----------------|
| 160                            | Identify as per dwg & Stock Location: <u>Steer</u> | 0.00                 |         |        |              |               |                  |                  |                |
| <b>*160*</b>                   |                                                    |                      |         |        |              |               |                  |                  |                |
| Packaging                      | Memo                                               | 0.20                 |         |        |              | 26            | DAS<br>6<br>9-89 | JUL 05 2016      |                |
| Packaging                      |                                                    |                      |         |        |              |               |                  |                  |                |
| 170                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |                  |                  |                |
| <b>*170*</b>                   |                                                    |                      |         |        |              |               |                  |                  |                |
| QC                             | Memo                                               | 2.00                 |         |        |              |               |                  |                  | 16/7/6 JD      |
| Quality Control                |                                                    |                      |         |        |              |               |                  |                  |                |

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JUL 06 2016

# Picklist Print

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Work Order ID: 146501

\*146501\*

Parent Item: D2528-1

\*D2528-1\*

Parent Item Name: Backer Plate

Start Date: 5/18/2016

Required Date: 5/31/2016

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP: C00.06.26Removed P/O for powder coatEC

IPP Rev:D 08-07-23 now made on water jet DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M5052H32S.063

Purchased

No

100

sf

18.6849

0.0303

0.637895

\*M5052H32S 063\*

\*\*

on 16/06/14

5052-H32 .063 Sheet

Location

Loc Qty

Loc Code

MAT022

18.6849

M128455

3.2849

M133557

15.4



|                      |                                |                                                      |                        |
|----------------------|--------------------------------|------------------------------------------------------|------------------------|
| DESIGN<br><i>KE</i>  | DRAWN BY<br><i>CP</i>          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA    |                        |
| CHECKED<br><i>KE</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2528                                 | REV. C<br>SHEET 1 OF 1 |
| DATE<br>98.12.10     | TITLE<br>BACKER PLATE          |                                                      | SCALE<br>1:1           |
| A                    | 96.12.12                       | NEW ISSUE                                            |                        |
| B                    | 97.10.10                       | CHANGE SIZE AND HOLE LOCATION                        |                        |
| C                    | 98.12.10                       | ADD D2528-1 AND -3 (TSR A1037)<br>UPDATED TOLERANCES |                        |
| CI                   | <del>05.04.27</del>            | 1.46 WAS 1.460; 1.00 WAS 1.000                       |                        |

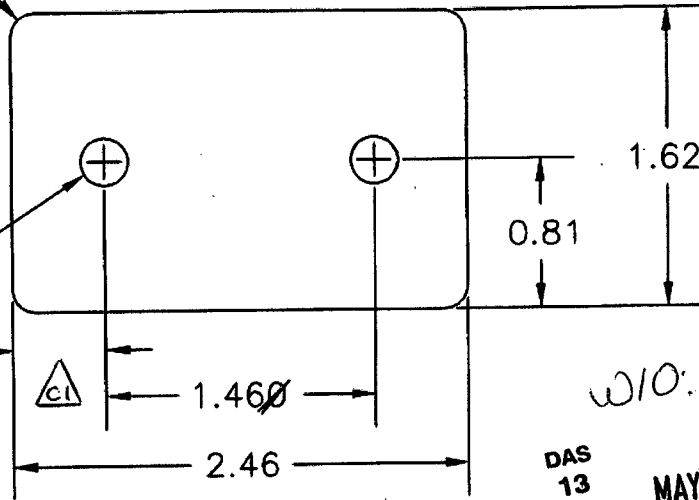
RELEASED  
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW  
*[Signature]*  
01/12/03

Ø0.257 (TYP)

0.50



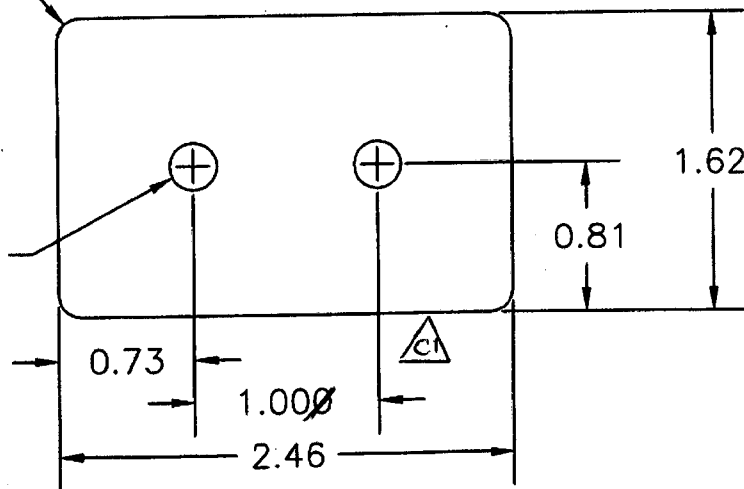
D2528-1

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9-89

MAY 18 2016

R0.13 (TYP)

Ø0.257 (TYP)



D2528-3

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3  
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

|                                             |  |                     |         |
|---------------------------------------------|--|---------------------|---------|
| <b>DART AEROSPACE LTD</b>                   |  | <b>Work Order:</b>  | 146503  |
| <b>Description:</b> Backer Plate            |  | <b>Part Number:</b> | D2528-1 |
| <b>Inspection Dwg:</b> D2528 <b>Rev:</b> C1 |  | <b>Page 1 of 1</b>  |         |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

| Drawing Dimension | Tolerance     | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.257            | +0.006/-0.001 | Ø.257            | /      |        | V: 02-02             |          |
| 0.50              | +/-0.030      | .498             | /      |        |                      |          |
| 1.46              | +/-0.030      | 1.460            | /      |        |                      |          |
| 0.81              | +/-0.030      | .811             | /      |        |                      |          |
| 1.62              | +/-0.030      | 1.62             | /      |        |                      |          |
| 2.46              | +/-0.030      | 2.462            | /      |        |                      |          |
| 0.063             | +/-0.010      | .059             | /      |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
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|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |
|                   |               |                  |        |        |                      |          |

|                     |          |                    |             |                            |     |
|---------------------|----------|--------------------|-------------|----------------------------|-----|
| <b>Measured by:</b> | DC       | <b>Audited by:</b> | 38<br>9.89  | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>        | 16/06/14 | <b>Date:</b>       | JUN 15 2016 | <b>Date:</b>               | N/A |

| Rev | Date     | Change    | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A   | 09.03.10 | New Issue | KJ/DD      | 18       |